

# Work Order ID 51801

Thursday, September 03, 2009 11:42:24 AM



Page 1

Item ID: D350-636-011

Accept



Setup Start



Revision ID: F

Stop



Item Name: Skidtube LH

Start Date: 9/3/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 9/15/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

*PL run*

Date:

*9-9-08*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2750

Rev F

0.00

0.00

100



DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy blue file and type labels per PPP D350-636-011 CHG 004

*8/10/07*

*HJ for BG 09/10/06*

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Cust Item ID:

Required Date: 9/15/2009 Req'd Qty: 1.00

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Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

110

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details).Drill using drill Jig DT8150 &amp; DT8863.

3- Mark fwd end for cutting using Drill Jig DT 8150 &amp; DT8863 and cut as per dwg D2750.

4- drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500"

5- locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting

6-Open up holes for Detail B to 0.375" (4 holes per side)and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750 .Open up holes for ground handling and detail C to 0.500" (8 holes per side)

7-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

8-Open up holes of Detail A to 0.297" (total of 2 holes per side)

9-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004

A/R□□□ Aluminum Rod

□ mill 682

10-Grind welds flush as per Dwg D2750

BE 09/09/14

AWM 9-7-16

BE 09/09/14

AWM 7-9-16

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Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

12- Scribe batch# inside per dwg D2750

120



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

2) Scribe batch#

(40)

/

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

2) Scribe batch#

(40)

/

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

DP  
9-9-16

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Cust Item ID:

Required Date: 9/15/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

QC3- Inspect Part Finish

0.00

2) 502/02/25



QC

Memo

0.00



Quality Control

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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

160

0.00



Skidtubes

Skidtubes

0.00

Skidtubes

Memo

1-Open up holes of Detail C and ground handling to 0.625" (total of 8 holes per side)  
as per dwg D2750.

2-Open up holes of Detail B to 0.750" (total of 4 holes per side)  
as per dwg D2750.

3- Open float hole to 0.500" (4 per side)

4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750  
(welding instructions on sheet 8)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R ☐☐☐ Sikaflex-291

batch: 1112391 ☐☐☐

exp. date: 02/20/2010

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004  
(welding instructions on sheet 8)

A/R ☐☐☐ Aluminum Rod

batch: 11109213

9-Grind welds flush as per Dwg D2750

10-Spot face ground handling holes section (total of 4 places per side) as per  
dwg D2750

9-9-25

PD 09.09.29

9-9-30

AWM 9-9-30

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Reference:

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

11-Deburr holes

DP 9-9-30

170



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

27 802/02/30

20

φ

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

27 802/02/30

20

φ

190



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

0.00

Memo

0.00

27 11/09/10/09

21

6

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

Powder Coating

START TIME: 8:30am  
OVEN TEMPERATURE: 320°F  
FINISH TIME: 9:00am

0.00

=&gt; 09/10/01

①

9

210

QC3- Inspect Part Finish

0.00



QC

Memo

Quality Control

Inspect for foreign object per QSI 024

0.00

BR 09-10-01

①

220

HandFinishing

0.00



HandFinish

Memo

Hand Finishing

1- Install inserts as per Dwg D2750

0.00

MD 09/10/02

X1

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Required Date: 9/15/2009 Req'd Qty: 1.00

Customer:

Reference:

Run Start

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

230

0.00



HandFinish

HandFinishing

Memo

0.00

Hand Finishing

1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3" batch: n/y

3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: m112391

EXP DATE: 10/20

4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube

A/R 55-o'ring lube batch: m101223

5-Coat all exposed fasteners with "LPS Procyon" batch: m104251

MO 09/10/02

MO 09/10/05

240

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

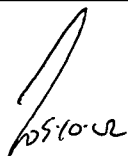
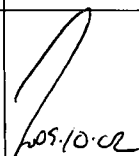
2501015

20

φ

P10  
Last  
Page



W/O: 51801		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
05-10-02	230	See NCR below to include the finish hole size in the W/O for clarification. on X-bolts per change	AK	07/10/13		 05-10-02	 05-10-02

Part No: D350-636-011 PAR #: \_\_\_\_\_ Fault Category: Skidplates NCR: Yes No DQA: AS Date: 05-10-14  
Resolution: re-work Disposition: re-work QA: N/C Closed: AS Date: 05-10-14

NCR: 51801		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/10/02	Found at step 230	Found During Assembly that the holes at Section AS-AS are too small (0.375"), welder used wrong drill bit.	<i>AS</i>	- Drill out + bolt space to 0.404" (7 Drill) + <i>blehman</i> - Touch up with Alumin AS <i>Reunus</i>	PD 09/10/02	<i>AS</i> 09/10/05	<i>AS</i>	<i>AS</i> 09/10/02
		R.C. wasn't seen at inspection also experienced welder (Don't know) <del>AND</del> DWG. has not inside hole dim. for hole	<i>AS</i>	- Touch up with iron AS <i>Re</i> QS2004 - Include hole sizes on work instructions for 0.404" OD	<i>AS</i> 09/10/05	<i>AS</i> 09/10/05	<i>AS</i>	<i>AS</i> 09/10/02
		R.C: Human error.						

NOTE: Date & initial all entries

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

250



Packaging

Packaging

Pick Kit

Memo

0.00

0.00

MO 09/10/07

X1

260



QC

Quality Control

QC4- 100% Inspect kits for completeness

Memo

\*\*\*\*\*ensure antiseize is on AN8C21A bolts\*\*\*\*\*

0.00

0.00

2) 802/10/07

(X) \$

270



Packaging

Packaging

Packaging

Memo

Package as per PPP D350-636-011

0.00

0.00

10/10/07

MUG

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Setup Start



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Cust Item ID:

Required Date: 9/15/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

09/10/13

ME 09-10-08

# Picklist Print

Thursday, September 03, 2009 11:42:33 AM

Page 1

Work Order ID: 51801

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH

Comments:

Start Date: 9/3/2009

Required Date: 9/15/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2744RevC		Manufactured	No			110	Each	50.0000	1.0000			
Cap												

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST                      50  
44892                      15  
47488                      35

D2600-3-BENTRevD1 ✓ Manufactured No



Extrusion Bent

D2743RevB Manufactured No



Crossbolt Spacer

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

LG                      50  
50281                      50

Main Warehouse

ST                      244  
44891                      2  
45555                      177  
48275                      65

*Handwritten notes:*  
BE 09/09/14  
R 50675 (1) BE 09/09/14  
R 50675 (1) 8

*Handwritten note:* 8 09.09.29

# Picklist Print

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Work Order ID: 51801



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 9/3/2009

Required Date: 9/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2739RevD		Manufactured	No			160	Each	6.0000	1.0000			

350 I Beam

B51919  
DP  
9-9-25

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
LG	4	
50353	4	
Main Warehouse		
ST	2	
47124	1	
47681	1	

D3490-3RevA

Manufactured No

160

Each

112.0000

4.0000



Cross Bolt Spacer

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	112	
45560	22	
47471	35	
48276	55	

4 PD 09.09.29

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Comments:

Start Date: 9/3/2009

Required Date: 9/15/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3490-1RevA		Manufactured	No			160	Each	165.0000	4.0000			
												
Cross Bolt Spacer												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	165	
45338	2	
47118	4	
47657	50	
48277	109	

ALS4-1032-225

Purchased

No

220

Each

8,785.000

38.0000



Insert

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	8785	
107441	16	
110768	8769	

D3492-041RevC

Manufactured

No

230

Each

3.0000

8.0000



Plug Assembly

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST	3	
43816	3	

4 PD 09.09.29

X38 MD 09/10/02

X8 MD 09/10/02

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Parent Item Name: Skidtube LH



Comments:

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Required Date: 9/15/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3793-3RevA		Manufactured	No			230	Each	22.0000	1.0000			
												
Wearshoe												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	22	
<u>47720</u>	11	
50216	11	

X1 MO 09/10/02

AN8C35A

Purchased

No

230

Each

167.0000

1.0000



BOLT

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	167	
102180	1	
106896	1	
<u>110103</u>	65	
110847	100	

X1 MO 09/10/02

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Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3793-1RevA		Manufactured	No			230	Each	18.0000	1.0000			
Wearshoe												

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST    18

40551    1

47537    4

50231    13

D3488-041RevB

Manufactured      No



230

Each

29.0000

1.0000



Blade Fitting Assembly, LH

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST    29

41853    1

44530    8

47348    20

XI      MD 09/10/02

XI      MD 09/10/02



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Start Date: 9/3/2009

Required Date: 9/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To-Pick	Qty Issued	Date Issued	Status
D37943RevA		Manufactured	No			230	Each	27.0000	1.0000			
Gasket												

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST	27	
46531	2	
47440	2	
47722	11	
<u>50240</u>	12	

AN6C44A

Purchased

No

230

Each

172.0000

4.0000



BOLT



Warehouse                      Loc Qty                      Loc Code  
Location

OFFSHORE

FG	2	
103964	2	

Main Warehouse

ST	170	
110105	4	
110155	14	
110665	1	
<u>110865</u>	51	
111605	50	
111649	50	

X1 MD 09/10/02

X4 MD 09/10/02

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Shop Packet Print

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Start Qty: 1.00

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21083C8		Purchased	No			230	Each	92.0000	1.0000			
												
NUT												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	92	
110584	5	
111424	2	
111637	21	
112243	44	
112492	20	

X1 MD 09/10/02

D3536-25RevA

Manufactured No



Gasket

230 Each 21.0000 1.0000



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	21	
45569	1	
47011	2	
47526	8	
60266	10	

X1 MD 09/10/02

Thursday, September 03, 2009 11:42:33 AM

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Thursday, September 03, 2009 11:42:33 AM

Work Order ID: 51801



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 9/3/2009

Required Date: 9/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3631-1RevA  Washer		Manufactured	No			230	Each	105.0000	8.0000			

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST    105

38139    6

45353    16

47437    83

D3791-1RevA

Manufactured      No



Wearplate

230                      Each                      18.0000                      1.0000



Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST    18

47536    8

50269    10

18 mp 09/10/02

11 mp 09/10/02

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# Picklist Print

Page 9

Thursday, September 03, 2009 11:42:33 AM

Work Order ID: 51801



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 9/3/2009

Required Date: 9/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960C10L		Purchased	No			230	Each	2,450.000	38.0000			



washer



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE	112612	
FG	100	
103585	100	
Main Warehouse		
FP	-44	
112116	-44	
Main Warehouse		
ST	2394	
112116	2394	

x38 mp 09/10/09

# Picklist Print

Page 10

Thursday, September 03, 2009 11:42:33 AM

Work Order ID: 51801



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 9/3/2009

Required Date: 9/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2745RevB		Manufactured	No			230	Each	272.0000	8.0000			



Bushing

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 272

34817 2

36230 8

37303 1

39587 2

40726 2

41114 2

42778 19

43754 2

44893 37

45556 69

46695 18

48278 110

X8 MD 09/10/02

AN3C5A

Purchased

No

230

Each

646.0000

34.0000



Bolt

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 646

111424 8

111707 338

112314 200

112489 100

X34 MD 09/10/02

Thursday, September 03, 2009 11:42:33 AM

Shop Packet Print

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# Picklist Print

Page 11

Thursday, September 03, 2009 11:42:33 AM

Work Order ID: 51801

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH

Comments:

Start Date: 9/3/2009

Required Date: 9/15/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3537-1RevC

Manufactured

No

230

Each

46.0000

3.0000



Wearpad

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

46

48288

3

50321

43

AN960C816L

Purchased

No

230

Each

330.0000

1.0000



WASHER

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

330

104093

2

107520

4

110139

29

110372

36

110584

100

111424

159

D3492-043RevC

Manufactured

No

230

Each

0.0000

8.0000



Plug Assembly

51642

X3 mo 09/10/02

X1 mo 09/10/02

X8 mo 09/10/02

Thursday, September 03, 2009 11:42:33 AM

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# Picklist Print

Thursday, September 03, 2009 11:42:33 AM

Work Order ID: 51801

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH

Comments:

Start Date: 9/3/2009

Required Date: 9/15/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN3C6A Purchased No 230 Each 1,048.000 4.0000



BOLT

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1048	
110372	72	
111982	976	

24 MD 09/10/02

NAS1611-013 Purchased No 230 Each 320.0000 1.0000



O-RING

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	320	
106513	11	
11424	109	
111758	200	

28 MD 09/10/02

NAS1611-010 Purchased No 230 Each 345.0000 1.0000



O-RING

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	345	
110715	50	
110915	295	

P10 - D

W/O: 51801		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09/10/02		Replaced O-Ring NAS 1611-010 By O-Ring D 2594-3 Batch: 851613 X8 Qty should be 8 for O-rings	MD	09/10/02	8		09/09/02

Part No: D350-636-011 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Thursday, September 03, 2009 11:42:34 AM

Work Order ID: 51801

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH

Comments:

Start Date: 9/3/2009

Required Date: 9/15/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3535-25RevB		Manufactured	No			230	Each	11.0000	1.0000			

 Wearshoe

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST

11

47523

11

X1 MD 09/10/02

D3794-1RevA

Manufactured

No

230

Each

7.0000

1.0000



Gasket

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST

7

46530

1

47212

2

47721

4

X1 MD 09/10/02

MS21043-6

Purchased

No

230

Each

1,132.000

4.0000



NUT

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST

1132

110584

34

111424

98

112314

1000

X4 MD 09/10/02

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Shop Packet Print

# Picklist Print

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Thursday, September 03, 2009 11:42:34 AM

Work Order ID: 51801



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 9/3/2009

Required Date: 9/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
S D3493-1RevA  Washer		Manufactured	No			260	Each	115.0000	2.0000			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 115

44902 15

47710 100

MS21083C8

Purchased

No

260

Each

92.0000

2.0000

2x 47710 mo 09/10/07



NUT

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 92

110584 5

111424 2

111637 21

112243 44

112492 20

2x 112243 mo 09/10/07

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# Picklist Print

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Thursday, September 03, 2009 11:42:34 AM

Work Order ID: 51801



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 9/3/2009

Required Date: 9/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN8C21A		Purchased	No			260	Each	112.0000	2.0000			



BOLT

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST

112

105160

1

107596

1

107924

2

109092

2

110341

2

110342

4

111605

50

111684

50

2 X 111684 MD 09/10/07

AN960C816L

Purchased

No

260

Each

330.0000

2.0000



WASHER

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST

330

104093

2

107520

4

110139

29

110372

36

110584

100

111424

159

2 X 111424 MD 09/10/07

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# Picklist Print

Thursday, September 03, 2009 11:42:34 AM

Work Order ID: 51801

Parent Item: D350-636-011RevF

Parent Item Name: Skidtube LH

Comments:

Start Date: 9/3/2009

Required Date: 9/15/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS1515H3L		Purchased	No			260 230	Each	350.0000	4.0000			

WASHER

Warehouse Loc Qty Loc Code

Location

OFFSHORE

FG 40

102472 40

Main Warehouse

ST 310

110450 2

110806 8

111819 300

D2741RevC

Manufactured No

260

Each

40.0000

1.0000

Blade, 350 Skidtube

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 40

20770 0

45320 1

47113 39

xy MD 09/10/02

(X47113 MD 0911062

# Picklist Print

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Thursday, September 03, 2009 11:42:34 AM

Work Order ID: 51801



Parent Item: D350-636-011RevF



Parent Item Name: Skidtube LH

Start Date: 9/3/2009

Required Date: 9/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3532-1RevA		Manufactured	No			260	Each	43.0000	2.0000			
<div> </div>												
Spacer												

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST    43

38161    2

44904    41

NAS1515H8L

Purchased

No

260

Each

129.0000

2.0000



WASHER

2x 44904 mo 09/10/07

Warehouse                      Loc Qty                      Loc Code  
Location

Main Warehouse

ST    129

107581    34

108964    1

11650    94

2x 11650 mo 09/10/07

W/O 51401

8 7 6 5 4 3 2 1

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

# GENERAL NOTES:

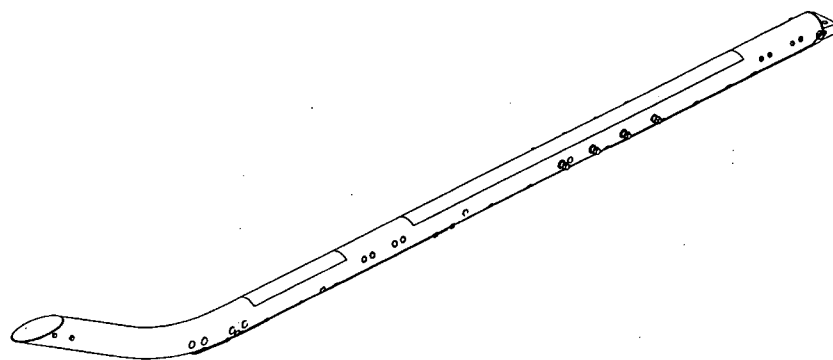
- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:  
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ( $\phi 0.297$ ) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.  
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

RELEASED

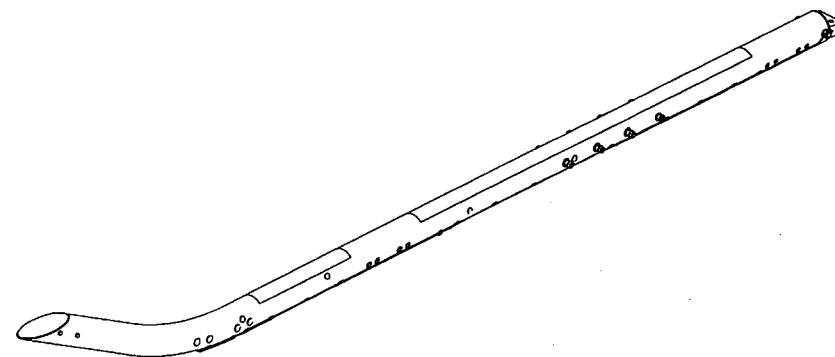
F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS, CHANGE INSERTS, ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	PA	DART AEROSPACE USA, INC.	
DRAWN	PA	PORT HADLOCK, WA	
CHECKED	PA	DRAWING NO.	REV. F
MFG. APPR.	PA	D2750	SHEET 1 OF 11
APPROVED	PA	TITLE	SCALE
DE APPR.	PA	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

8 7 6 5 4 3 2 1

W/O 51801



D2750-041 350 SKIDTUBE ASSEMBLY, LH

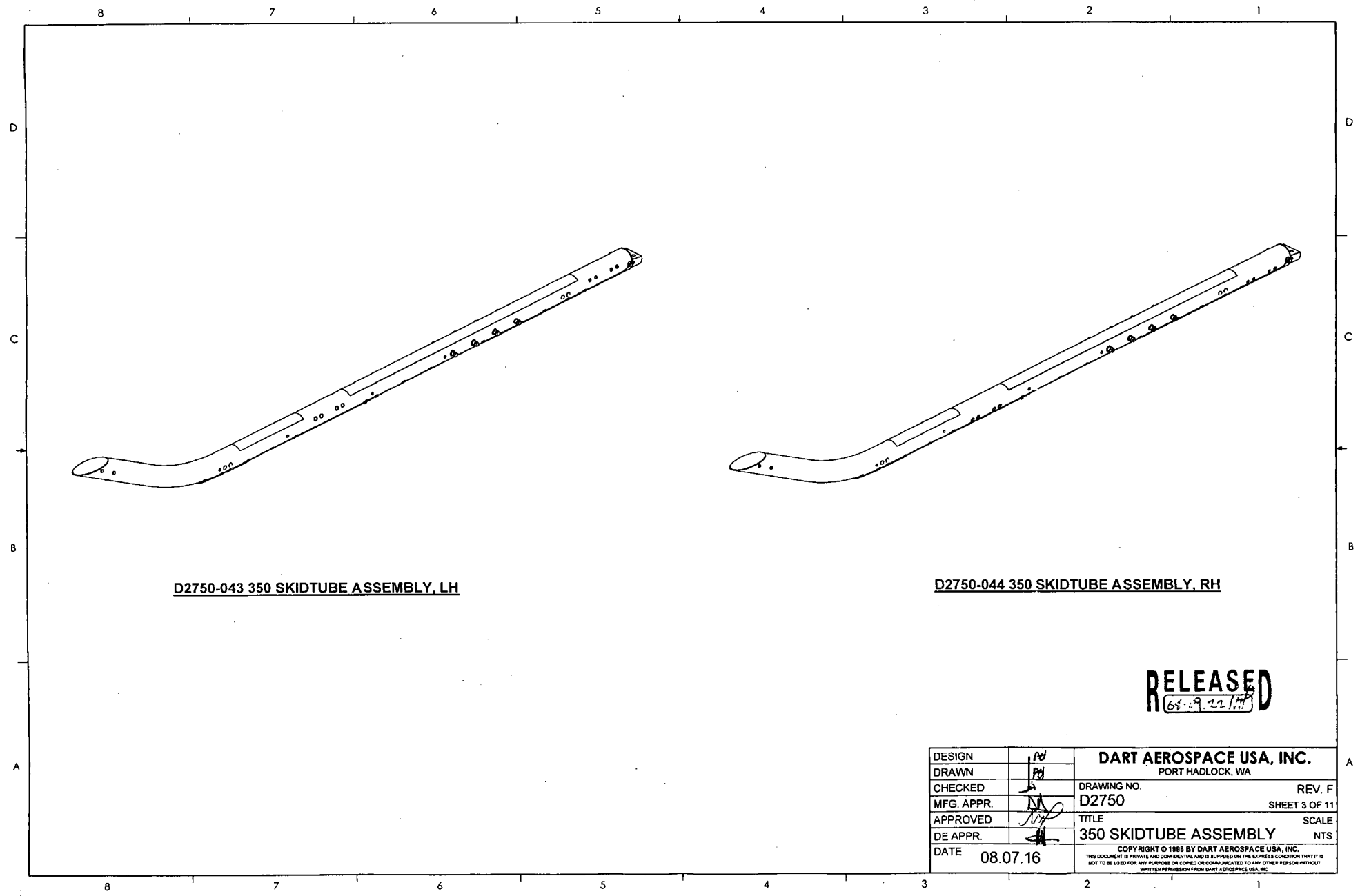


D2750-042 350 SKIDTUBE ASSEMBLY, RH

**RELEASED**  
18 JAN 77

DESIGN	PC	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	PA	PORT HADLOCK, WA	
CHECKED	PA	DRAWING NO.	REV. F
MFG. APPR.	PA	D2750	SHEET 2 OF 11
APPROVED	MA	TITLE	SCALE
DE APPR.	MA	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O 51801



D2750-043 350 SKIDTUBE ASSEMBLY, LH

D2750-044 350 SKIDTUBE ASSEMBLY, RH

RELEASED  
68-09-22/111

DESIGN	LD	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	LD	PORT HADLOCK, WA	
CHECKED	LD	DRAWING NO.	REV. F
MFG. APPR.	NA	D2750	SHEET 3 OF 11
APPROVED	NA	TITLE	SCALE
DE APPR.	LD	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1985 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

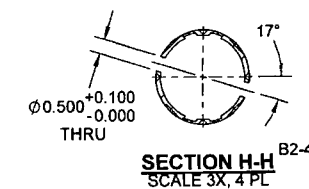
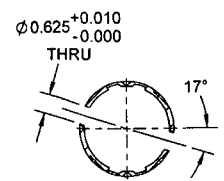
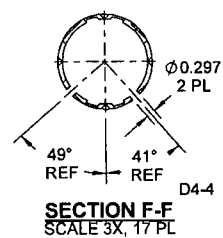
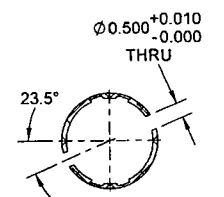
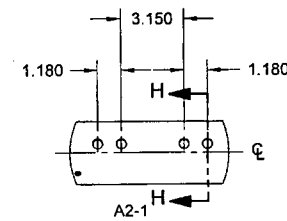
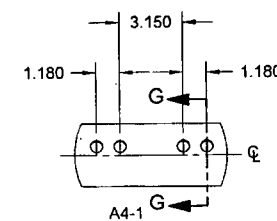
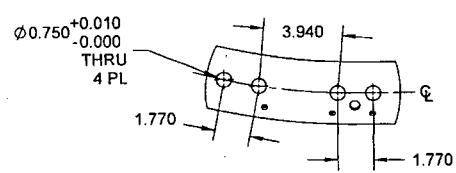
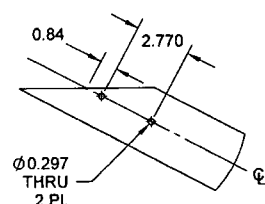
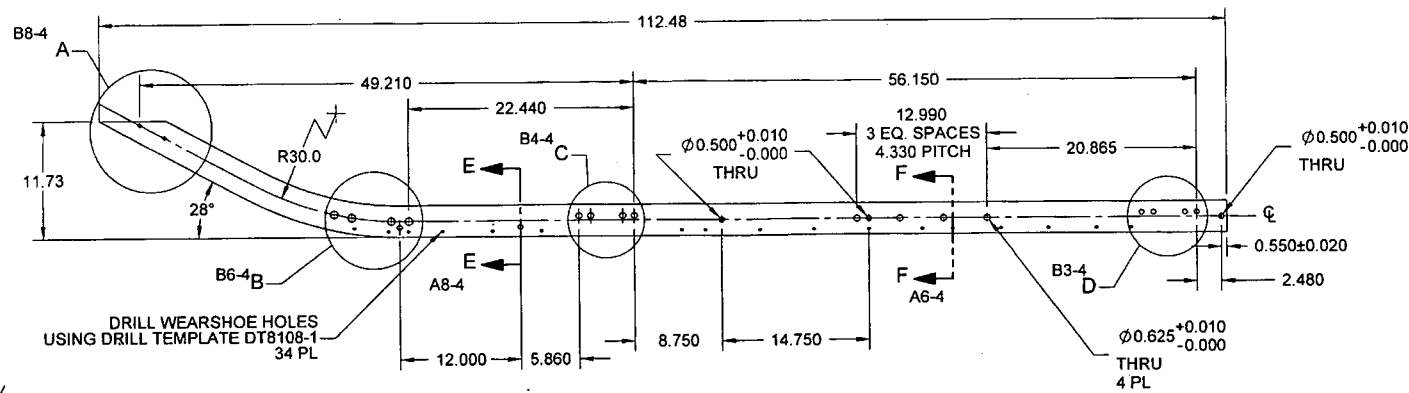


W/O 5180J

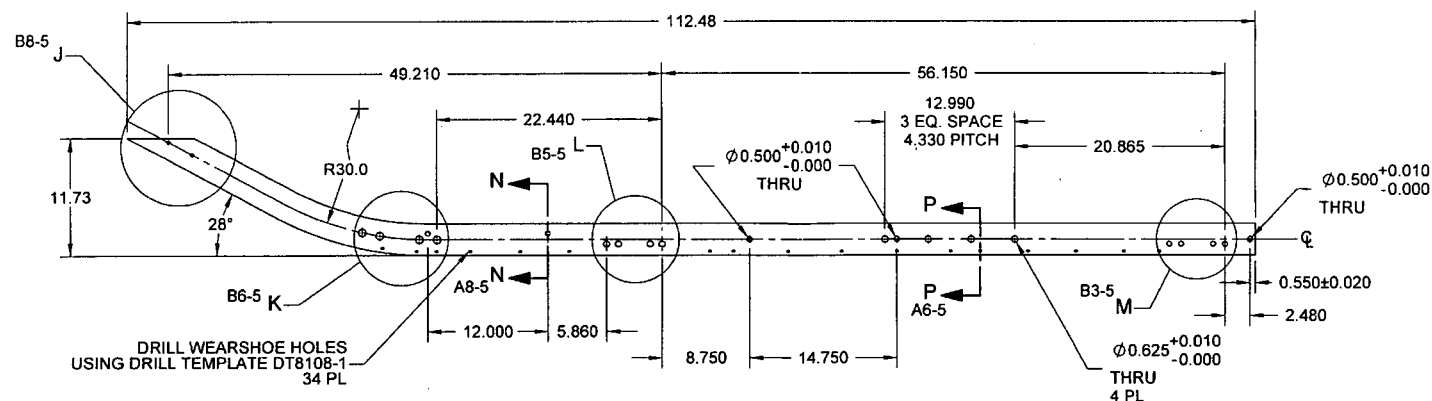
# **D2750-1 LH SKIDTUBE**

**RELEASED**

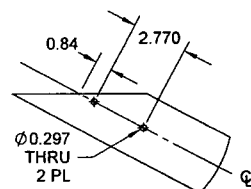
DESIGN	PM	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	PM	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		<b>D2750</b>	SHEET 4 OF 11
APPROVED		TITLE	SCALE
DE APPR.		<b>350 SKIDTUBE ASSEMBLY</b>	NTS
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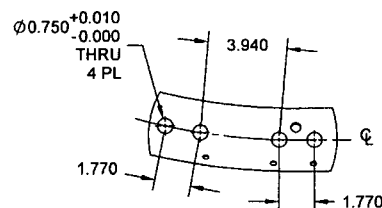
W/051801



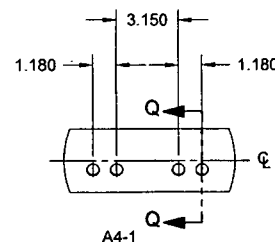
**D2750-2 RH SKIDTUBE**



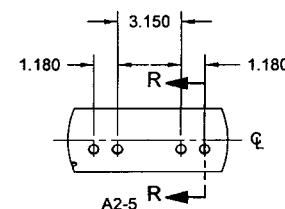
**DETAIL J**  
SCALE 2X



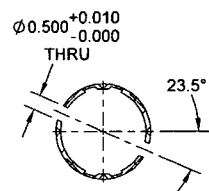
**DETAIL K**  
SCALE 2X



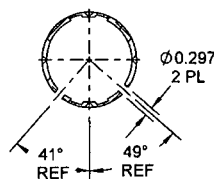
**DETAIL L**  
SCALE 2X



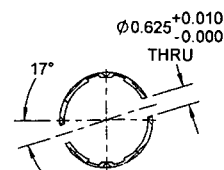
**DETAIL M**  
SCALE 2X



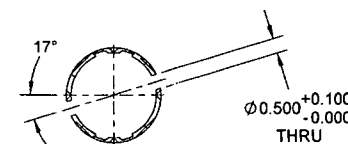
**SECTION N-N**  
SCALE 3X, 2 PL



**SECTION P-P**  
SCALE 3X, 17 PL



**SECTION Q-Q**  
SCALE 3X, 4 PL

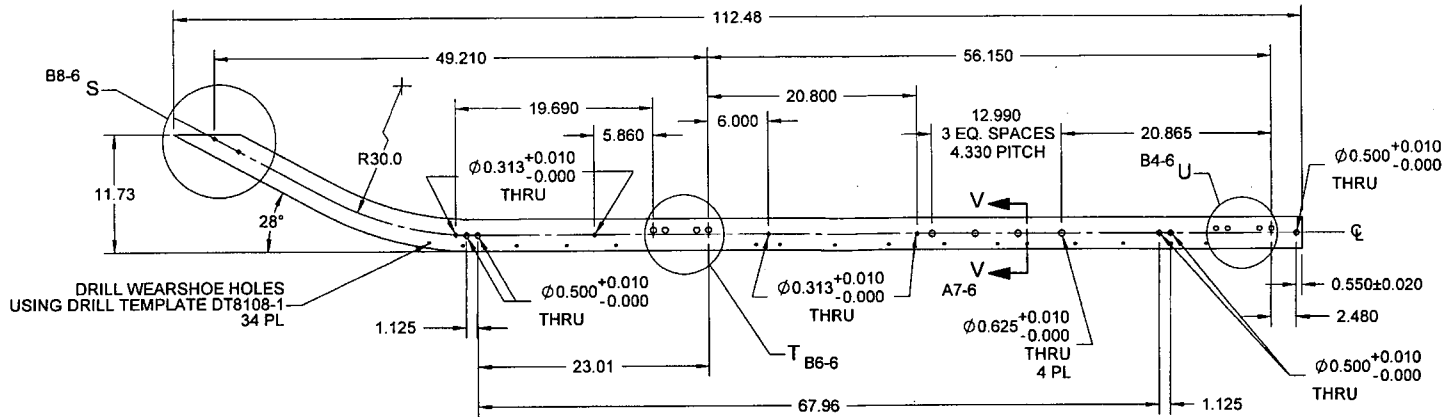


**SECTION R-R**  
SCALE 3X, 4 PL

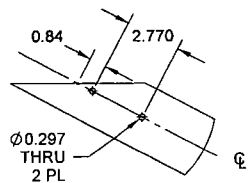
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MFG. APPR.		D2750	SHEET 5 OF 11
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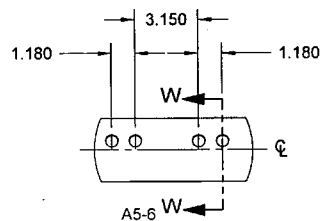
W/O 51801



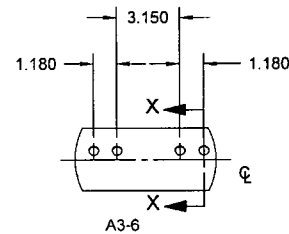
**D2750-3 LH SKIDTUBE**



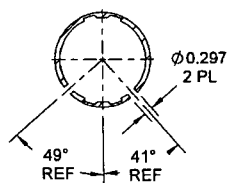
**DETAIL S**  
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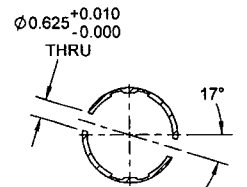
**DETAIL T**  
SCALE 2X



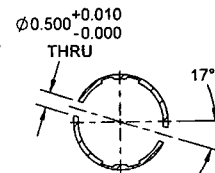
**DETAIL U**  
SCALE 2X



**SECTION V-V**  
SCALE 3X, 17 PL



**SECTION W-W**  
SCALE 3X, 4 PL



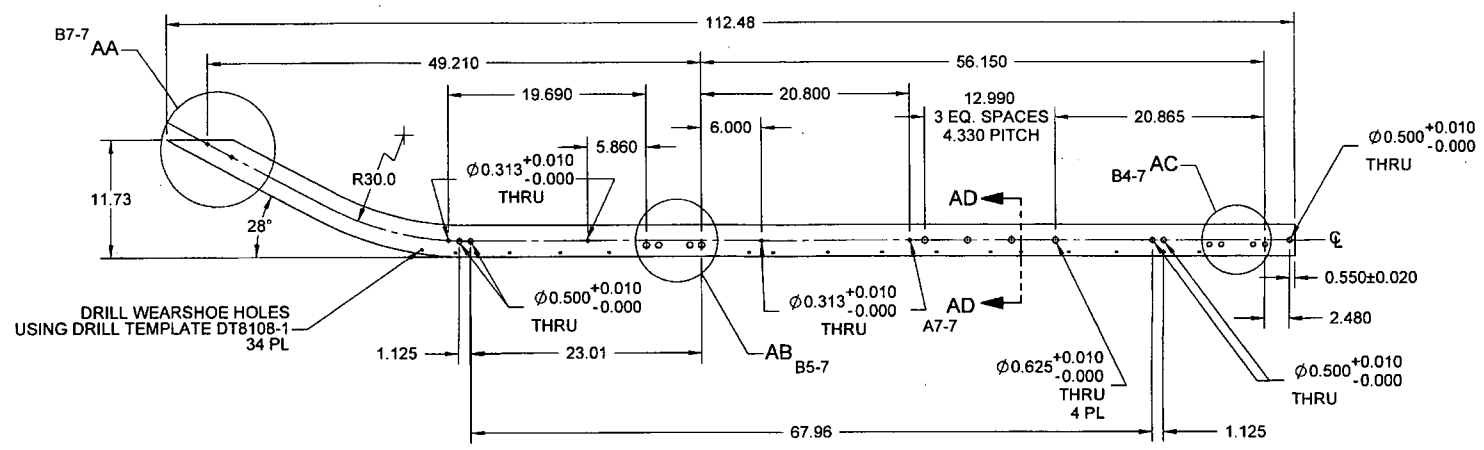
**SECTION X-X**  
SCALE 3X, 4 PL

**RELEASED**

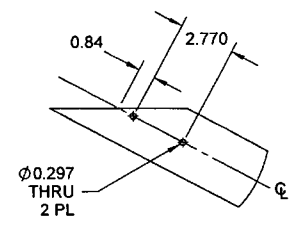
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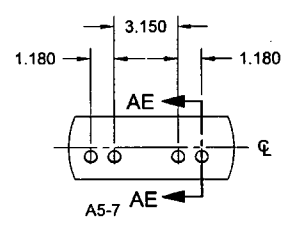
W/O 51801



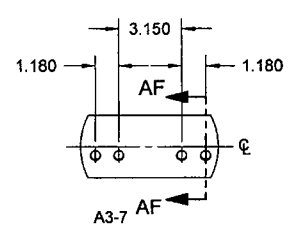
**D2750-4 RH SKIDTUBE**



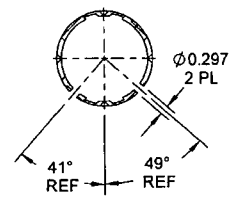
**DETAIL AA**  
SCALE 2X



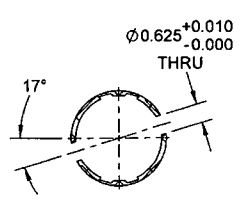
**DETAIL AB**  
SCALE 2X



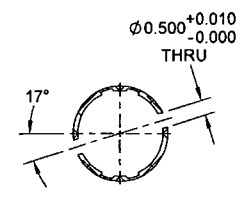
**DETAIL AC**  
SCALE 2X



**SECTION AD-AD**  
SCALE 3X, 17 PL



**SECTION AE-AE**  
SCALE 3X, 4 PL

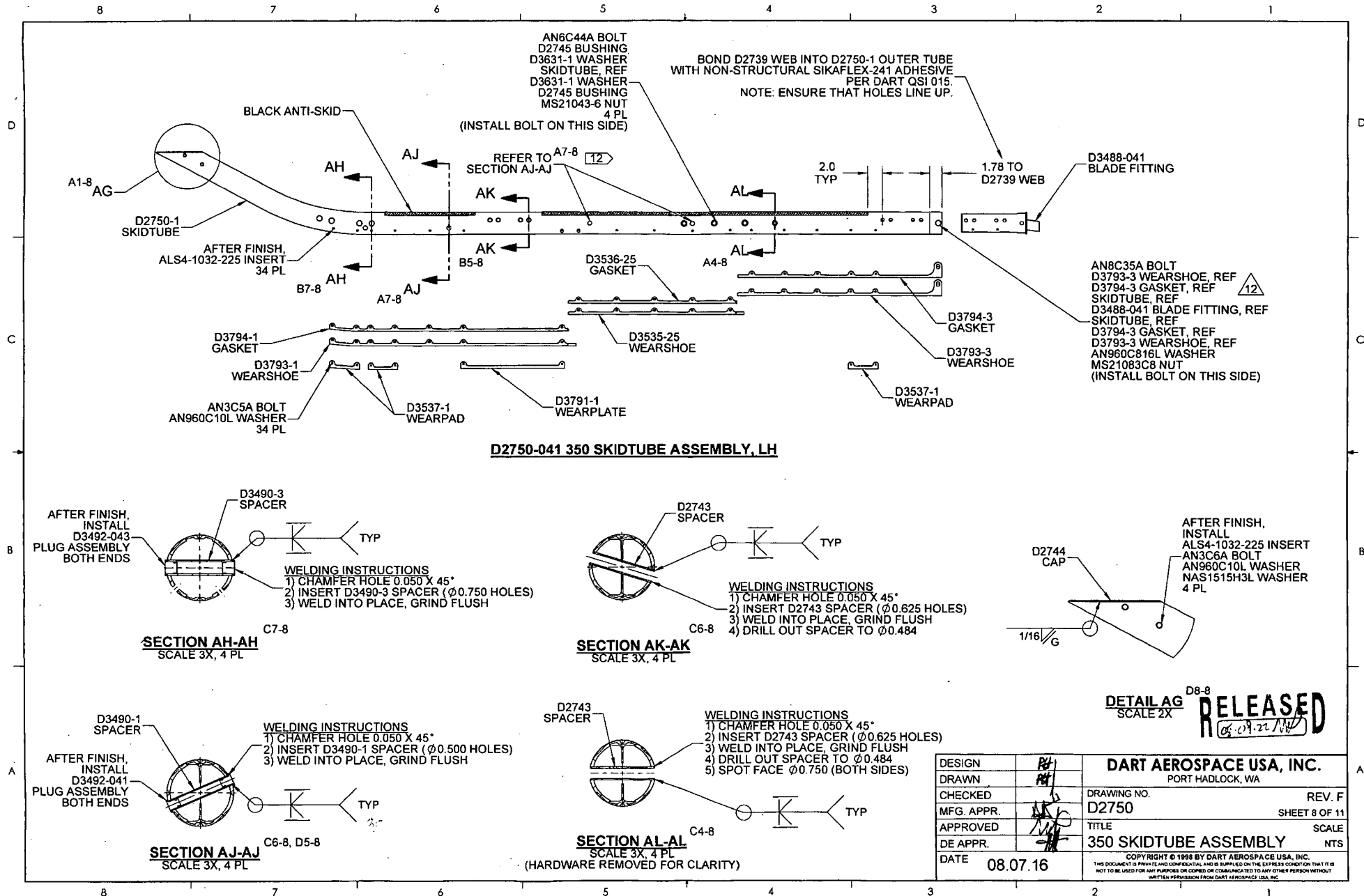


**SECTION AF-AF**  
SCALE 3X, 4 PL

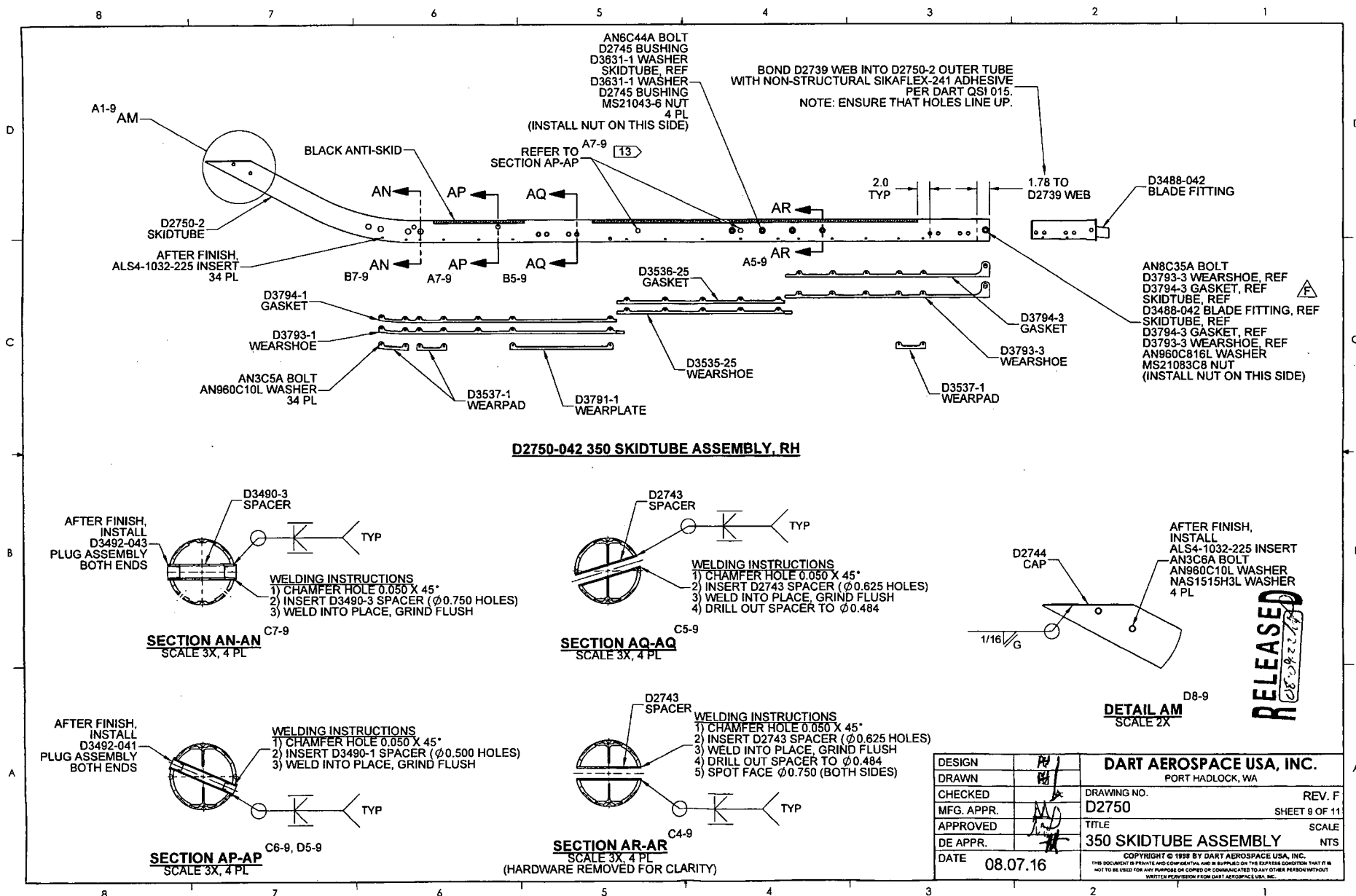
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W/O 5180,

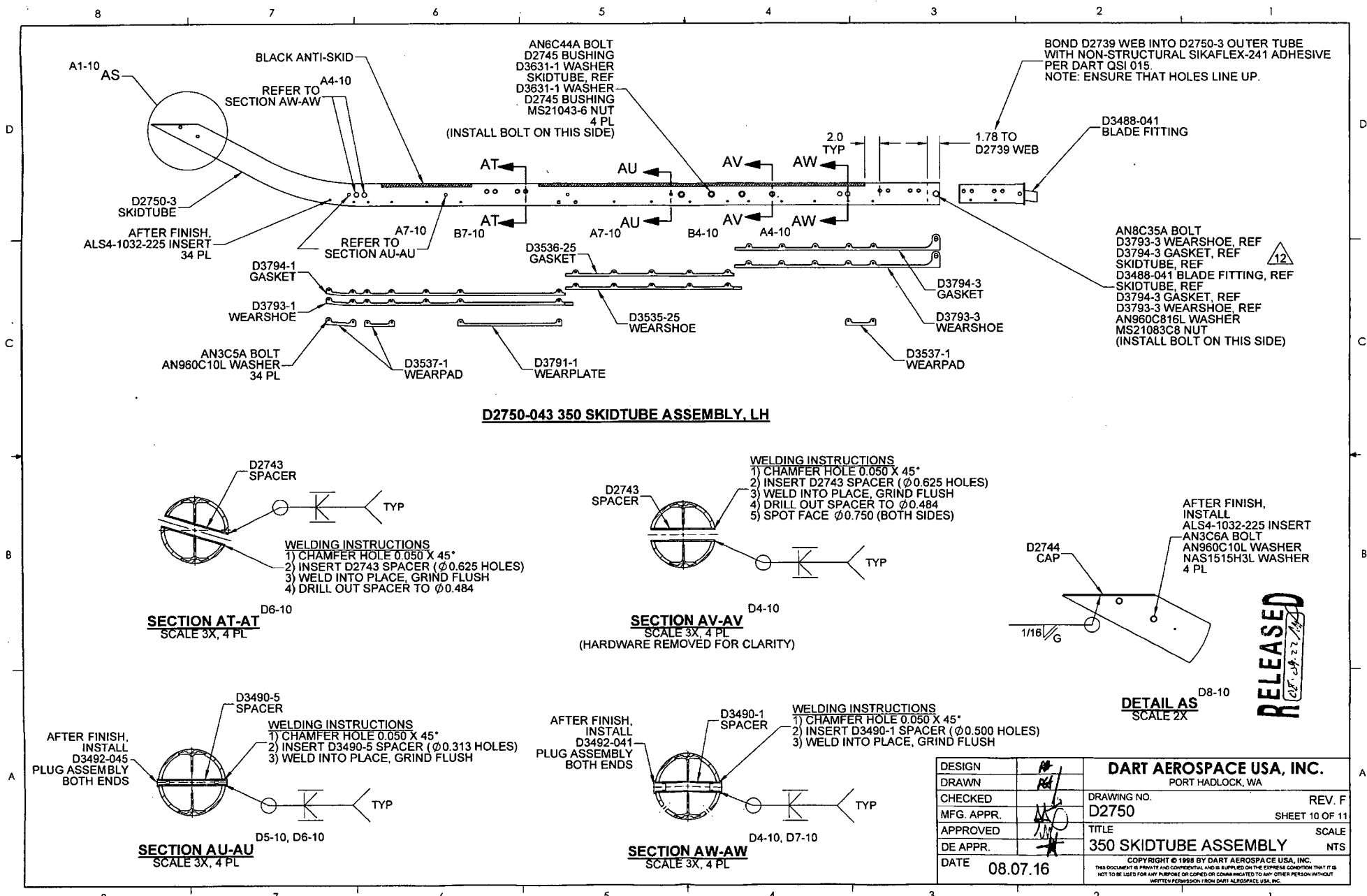


W/O 31801



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W/O 5/80



**D2750-043 350 SKIDTUBE ASSEMBLY, LH**

**SECTION AT-AT**  
SCALE 3X, 4 PL

**SECTION AV-AV**  
SCALE 3X, 4 PL  
(HARDWARE REMOVED FOR CLARITY)

**SECTION AU-AU**  
SCALE 3X, 4 PL

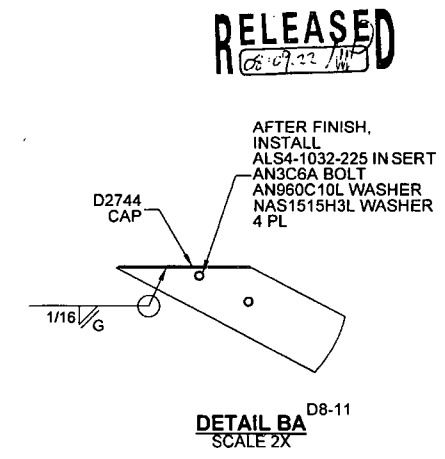
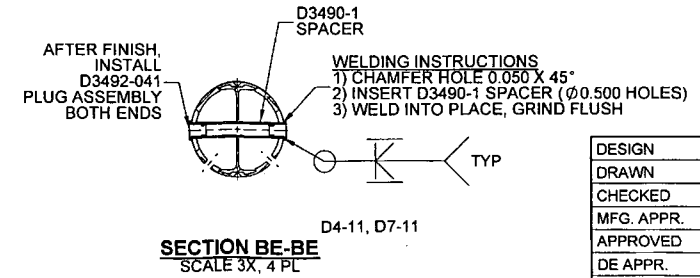
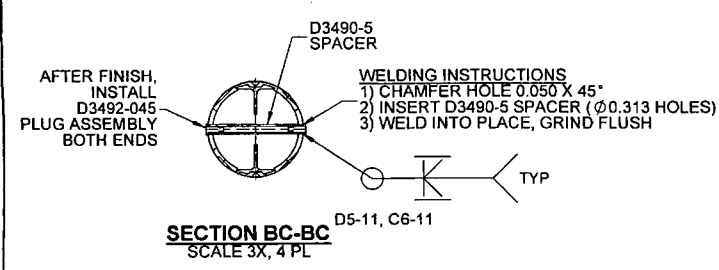
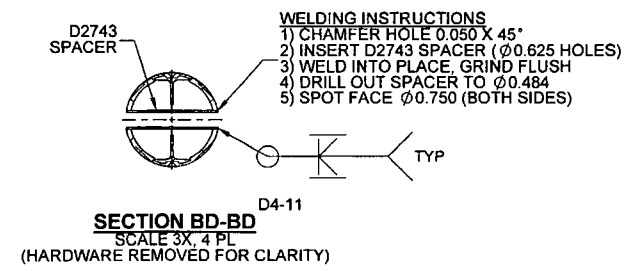
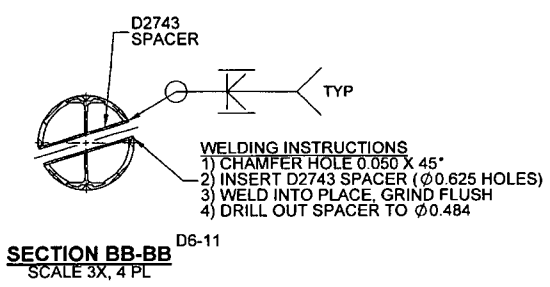
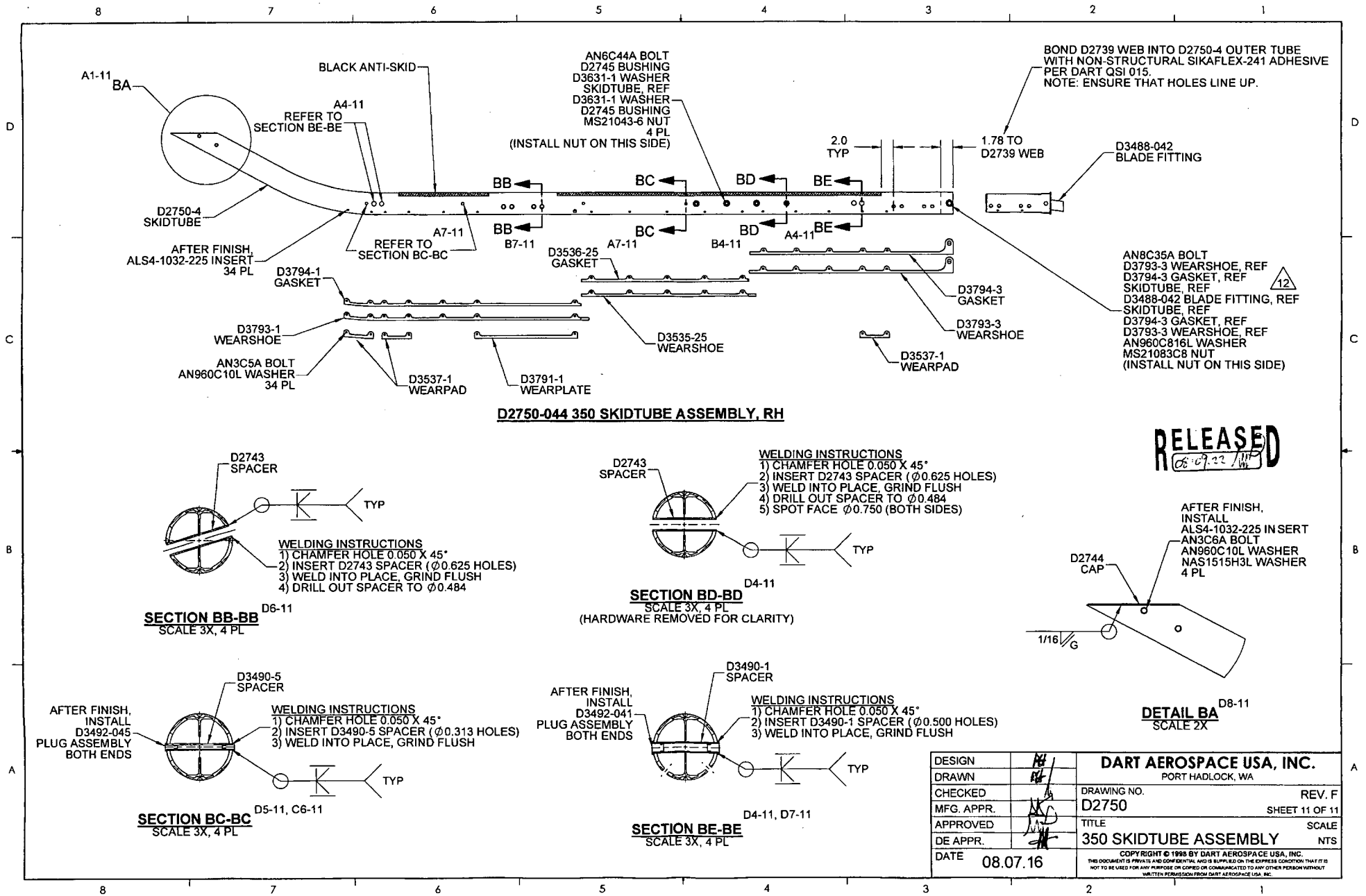
**SECTION AW-AW**  
SCALE 3X, 4 PL

**DETAIL AS**  
SCALE 2X

DESIGN		<b>DART AEROSPACE USA, INC.</b>
DRAWN		PORT HADLOCK, WA
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MFG. APPR.		REV. F
APPROVED		SHEET 10 OF 11
DE APPR.		TITLE <b>350 SKIDTUBE ASSEMBLY</b>
DATE	<b>08.07.16</b>	SCALE NTS

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MFG. APPR.	4/0 31801	D2750	SHEET 11 OF 11
APPROVED	4/0 31801	TITLE	SCALE
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NO. 209

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: A. R. Paul  
Job number: 51803  
Part number: A350-636-011  
Description: 350 Skid tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Alum  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier Daniel Paul Date of Test Coupon 09/09/08  
Welder A. R. Paul Date of Test Coupon 09.09.08

The above named individual is qualified in accordance with AWS D17.1.2001 to weld